

Date: Wednesday, 12/11/2008 1:30:11 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350/355 AS X-TUBE FWD
Job Number : 43337	
Estimate Number : 12485	
P.O. Number :	Part Number : D350748101
This Issue : 12/11/2008 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : CROSSTUBES	Drawing Revision : D
Previous Run : 43336	Material :
Written By :	Due Date : 02/12/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JLD 08.11.12</u>	
Comment :	
Est Rev:A New Issue 06-07-05 JLM	
Est Rev:B Update qty of MS21042L5 06-09-12 KJ	
Est Rev:C Rev B 07-11-15 DD	
Est Rev D Combined manufacturing 08.04.02 EC verified by: DD	
Est Rev:E 08-06-24 revD as per dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPPD350-748-101 CHG001.

2.0	D350748141TRN	Crosstube Turning Detail
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
CROSSTUBE TURNING DETAIL
batch B-42397

MB 08-11-20

3.0	BENDING	BENDING MACHINE - SKIDTUBES
-----	---------	-----------------------------



Comment: BENDING MACHINE

Bend tube as per Dwg D350-748-141 using CNC bender program D350F and Folio FT

DP 8-11-20

4.0	QC15	DIMENSIONAL CHECK OF X-TUBES
-----	------	------------------------------



Comment: DIMENSIONAL CHECK OF X-TUBES

MB 08.11.21

5.0	CROSSTUBES	CROSSTUBES RESOURCE 1
-----	------------	-----------------------



Comment: LANDING GEAR RESOURCE 1

1-Drill Tube as per Dwg D350-748-141 Using DT8876 A,B & C Drill Jigs,
Set-up drill table as per QSI 010

2-Deburr

DP 8-11-26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 350/355 AS X-TUBE FWD

Job Number: 43337

Part Number: D350748101

Job Number:



Seq. #:

Machine Or Operation:

Description:

3-Engrave Part # and Batch # as per Dwg D350-748-141

DD/MP 8-11-26
- AWM 8-11-26

4-Remove all marks from tube within limits of D350-748-141

5- Apply a light coat of LPS3 on the interior of tube

Batch: *m 109539*

- FY 08/11/27 ①

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

CHECK 10 DEG HOLES WITH DT8876E(EUROCOPTER CLAMP)

08/11/27 ①

7.0

OUTSIDE SERV.11

OUTSIDE SERVICE -CROSSTUBES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: *7700*

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2

Embrittle relief at 375° for 8 hours, Chromate Treat

Possible Supplier: Southwest United Industries

Ensure Certificate of Conformity is attached

08/11/27 ①

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

08/12/22 ①

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside crosstube as per QSI 005 4.2

2-Prime Outside of Tube as per Dart QSI 005 4.2

08-12-23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: 350/355 AS X-TUBE FWD

Job Number: 43337

Part Number: D350748101

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

11.0

QC14

INSPECT SPRAY PAINT



ml 08 12 24



①

Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

12.0

D35021

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SUPPORT

Batch: 42968

ml 08 12 29

13.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2401 f(s)/Unit Total : 1.2401 f(s)

Abrasion Strip 7.10" long x2

Batch: 31661

ml 08 12 29

14.0

ALS41032225

Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Insert

Batch: 109817

ml 08 12 29

15.0

AN960JD10

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

Batch: 105442

ml 08 12 29

16.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp (per MIL-DTL-8783C)

Batch: 109715

ml 08 12 29

17.0

MS27039110

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Screw

Batch: 18836

ml 08 12 29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: 350/355 AS X-TUBE FWD

Job Number: 43337

Part Number: D350748101

Job Number:



Seq. #: Machine Or Operation: Description :

18.0 CROSSTUBES CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install Ground wire Insert, then insert screw and washer

2-Install Abrasion strips as per Dwg D350-748-141 & QSI 035.

3-Install supports Using Dt8876 as per Dwg D350-748-141, Torque to 60-80 IN-LBS

ml 08 12 29 (1)

19.0 QCS INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.12.30 (1)

20.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

21.0 D35001 Saddle



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
350 SADDLE
Batch: 8/555

SD

22.0 D35011 Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)
BUSHING
Batch: 1539726

SD

23.0 AN46A Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)
Bolt
Batch: M109545

SD

24.0 AN441A bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
bolt
Batch: M109632

8/12/30

SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 43337

Part Number: D350748101

Job Number:



Seq. #:	Machine Or Operation:	Description :
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25.0	AN532A	Bolt
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M109752

SP

26.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

Batch: M109249

SP

27.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M109752

SP

28.0	MS21042L4	Nut
------	-----------	-----



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Batch: M108145

SP

29.0	MS21042L5	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M109247

SP

30.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

31.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-101

Location: A

PPP Rev: 9/1/5

SP

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: 350/355 AS X-TUBE FWD

Job Number: 43337

Part Number: D350748101

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

AD 09/01/06

Job Completion



MF 09/01/06

09-01-05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

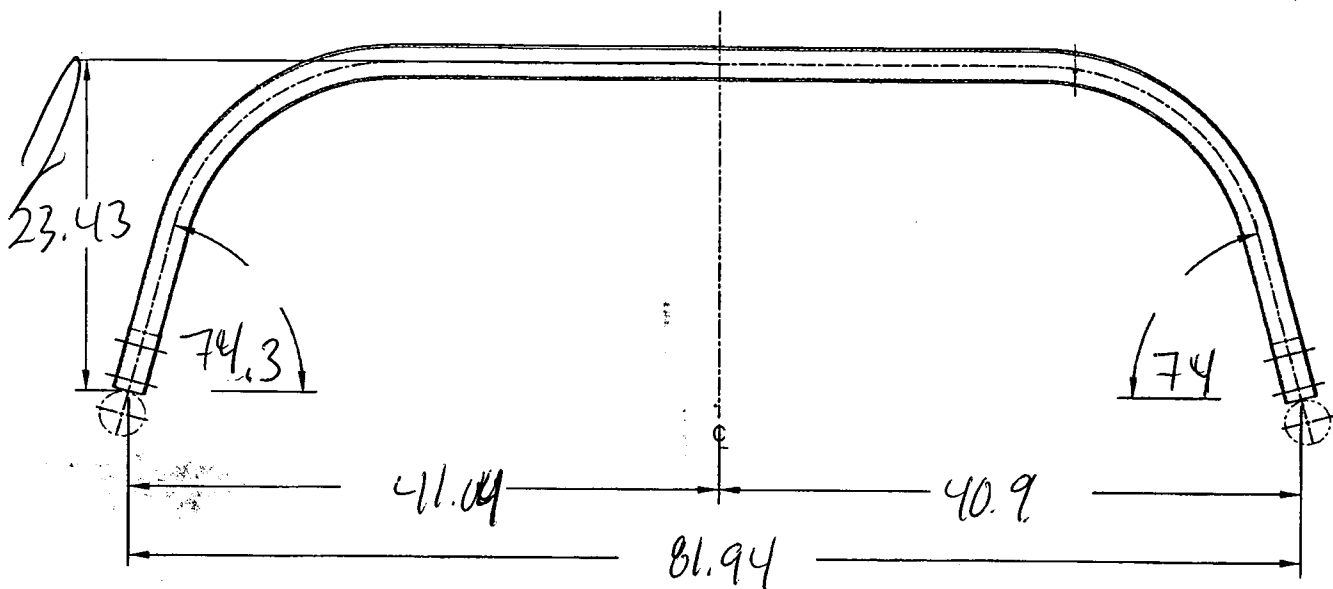
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 43337
Description: Crosstube High Fwd (AS350/355)	Part Number: D350-748-101
Inspection Dwg: D350-748-141 Rev: D	Page 1 of 1

Required Dimension	Min	Max
Height	23.13	23.37
1/2 Span	40.78	41.02
Angle	75	77
Total Span	81.56	82.04



Comments
Holes to be drilled 2 max up the cuff, i.e. 0.780"

QC15 Inspection	<i>[Signature]</i>
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



DESIGN <i>QP</i>	DRAWN BY <i>QP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. D350-748-141	REV. D SHEET 1 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI FWD)	SCALE NTS
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6017-115 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.	

RELEASED

06.10.31 *HA*

QTY	P/N	DESCRIPTION
X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
1	D6017-115	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

D350-748-141 CROSSTUBE:

- 1) MATERIAL: MANUFACTURED FROM D6017-115 OR D6015-125
FINISHED LENGTH = 110.27 ± 0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR $\varnothing 0.297$ HOLE.

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

UNDER REVIEW!

07.07.16 *HA*
CUT FOR REDUCED
07.07.16 *HA*

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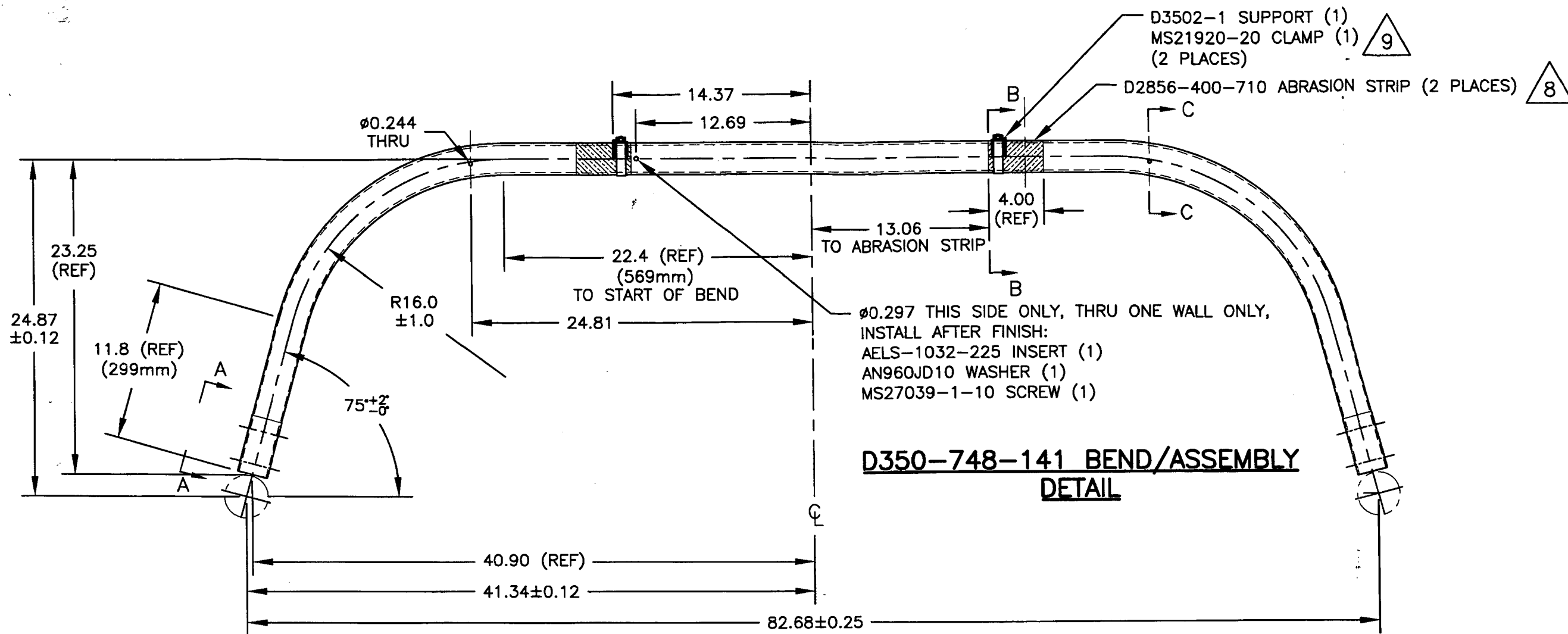
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

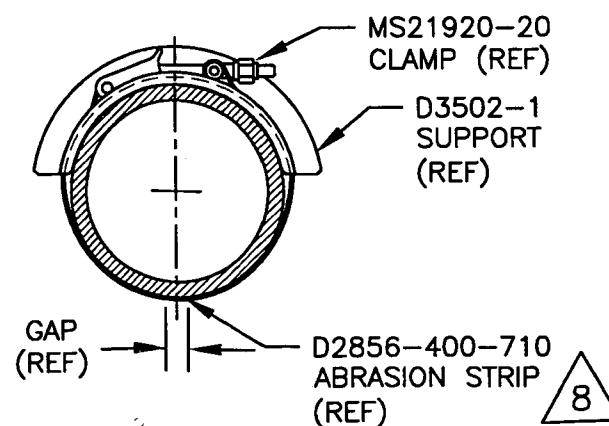
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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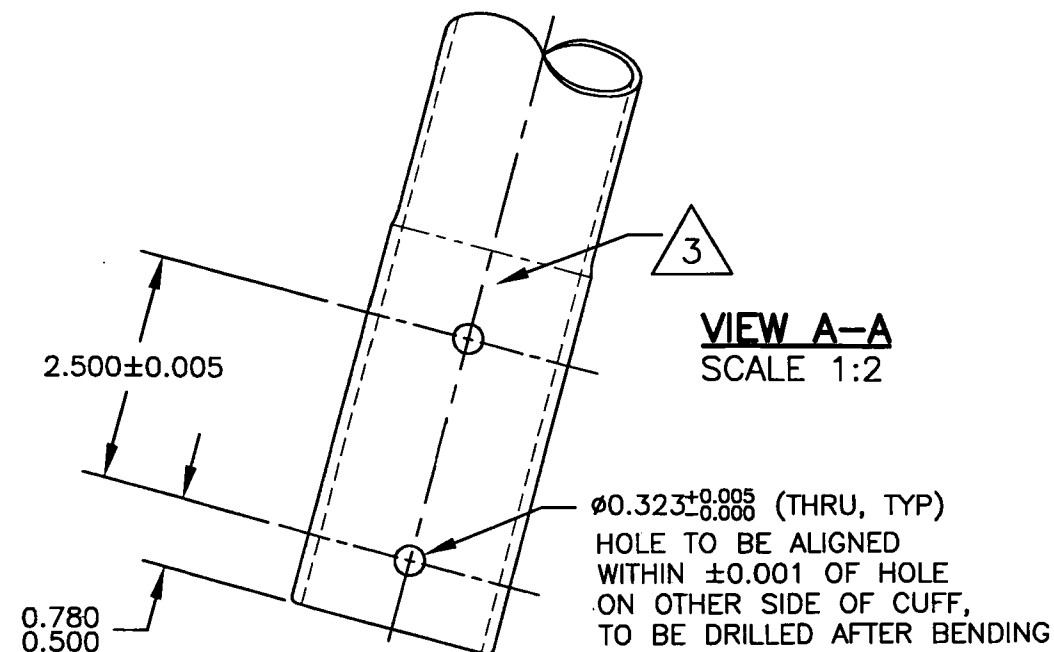
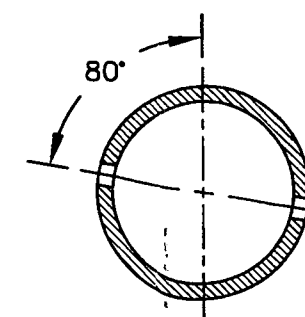
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SECTION B-B
SCALE 1:2



SECTION C-C
SCALE 1:2



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WORK ORDER
NO. 43337

UNDER REVIEW

07.02/16/17

CUFF FROM REWORK

OK UP 7.11.22

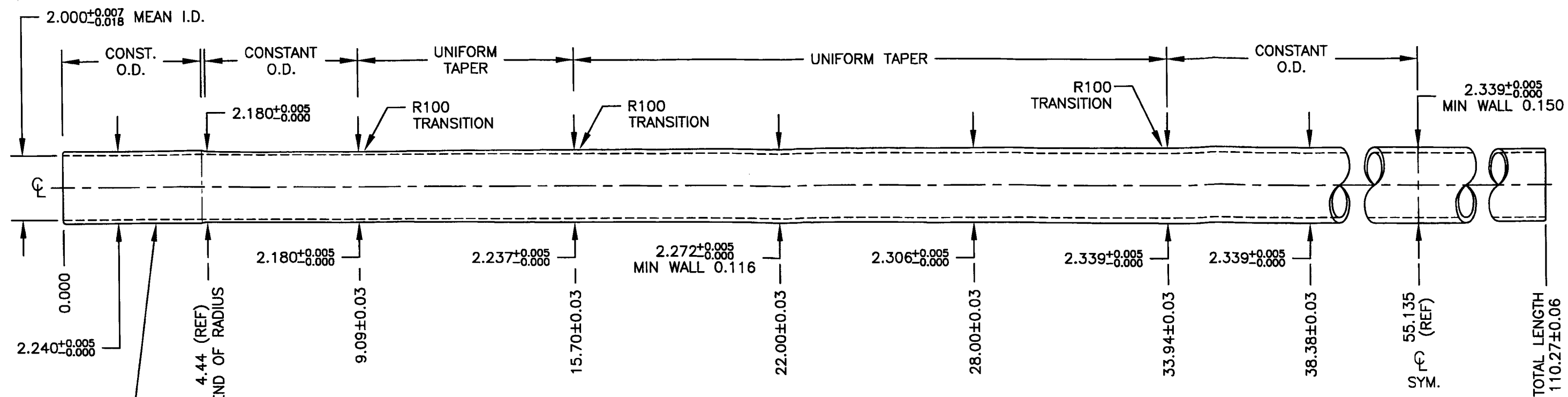
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06.10.31

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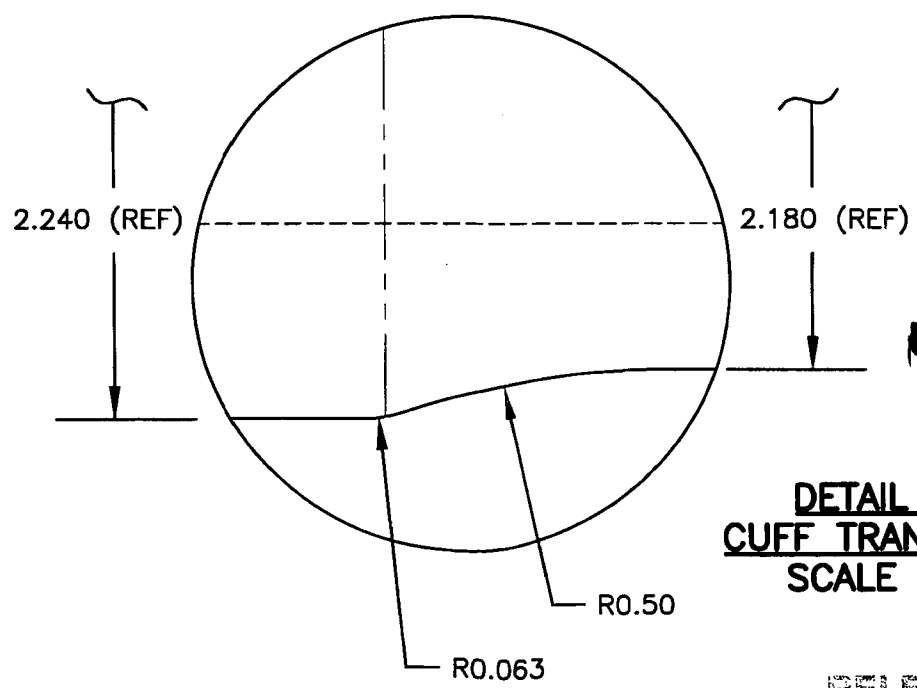
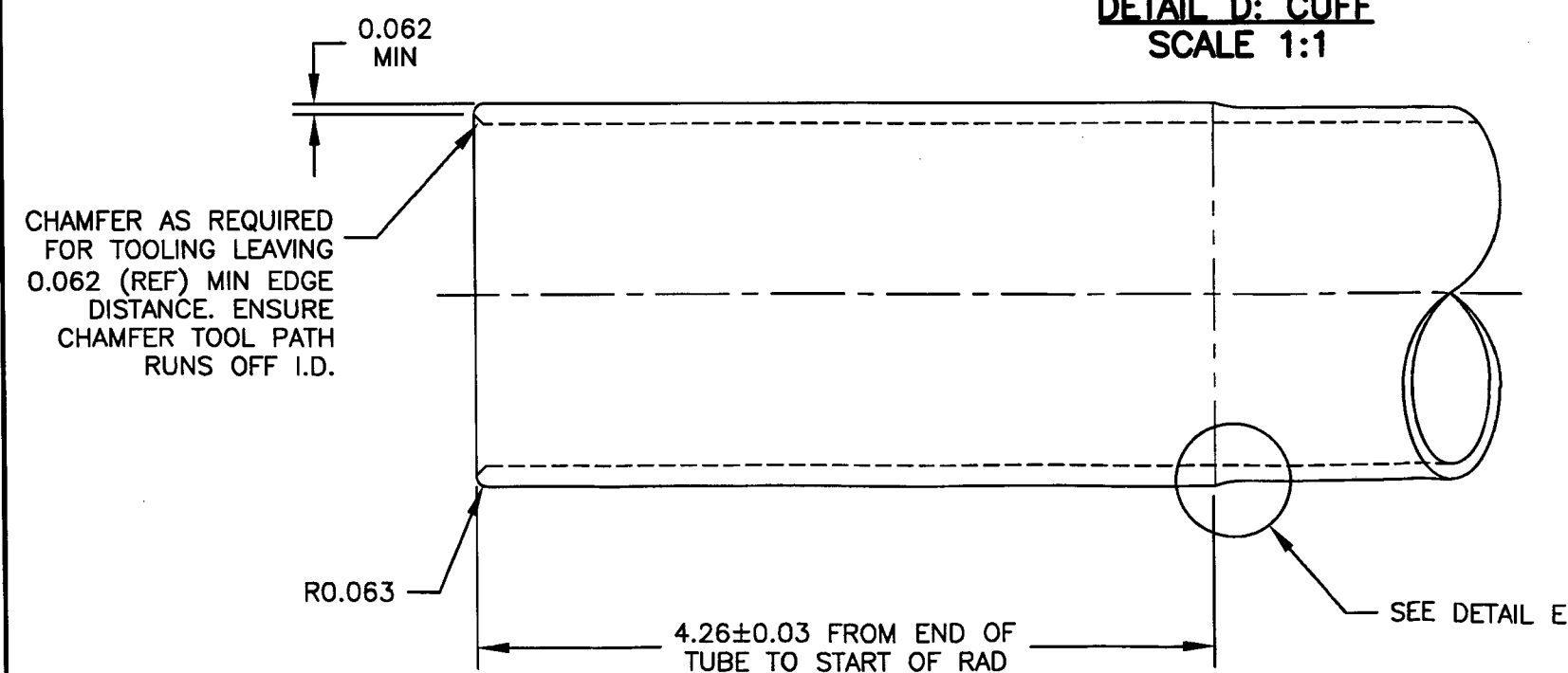
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DESIGN qp	DRAWN BY qp	DART	DART AEROSPACE LTD. HAMMERSBURY, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D350-748-141	REV. D SHEET 2 OF 3
DATE 06.10.31	TITLE CROSSTUBE (AS 350/355 HI FWD)	SCALE 1:8	



D350-748-141 MACHINING DETAIL

**DETAIL D: CUFF
SCALE 1:1**



**DETAIL E:
CUFF TRANSITION
SCALE 9:1**

UNDER REVIEW

07.02/16/17
CUFF JENK, REDUCED

07.07.17
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WORK ORDER

RELEASED

06.10.31

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DATE		06.10.31		DRAWING NO.	REV. D
				D350-748-141	SHEET 3 OF 3
				TITLE	SCALE
				CROSSTUBE (AS 350/355 HI FWD)	1:3

Packing Slip



Cadorath Plating Co. Ltd.

2150 Logan Avenue, Winnipeg, Manitoba R2R-0J2

Phone: (204) 633-9420 Fax: (204) 633-8033

INVOICE NUMBER:

42387

Sold To:

Dart Aerospace Ltd.

1270 Aberdeen St.

Hawksbury, ON K6A 1K7

ShipTo:

Net 2% Interest Per Month charged on Overdue Accounts.

Any claims for shortages, overcharges, or damaged goods must be made within seven (7) days from receipt of goods.

Customer Order #:	Date Received:	Terms:	G.S.T. #:	Ship Via:	Ship Date:
00007700	Dec-08-2008	NET 30 DAYS	0071 6547 RT0001		Dec-17-2008

Item #	Qty	P/N & Description	
1	1 EA	SKID	S/N B43336
		P/N d350-748-101	W/O 82376
2	1 EA	SKID	S/N B43337
		P/N d350-748-101	W/O 82377
3	1 EA	SKID	S/N B43339
		P/N d350-748-101	W/O 82378
4	1 EA	SKID	S/N B42538
		P/N d350-748-101	W/O 82379

**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: Dec-17-2008

CONIGNED TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7

W/O #: 82377

INVOICE #: 42387

**CONTRACT OR
PURCHASE ORDER # 00007700**

DESCRIPTION: SKID

QTY 1

P/N # d350-748-101

S/N # B43337

**STRESS RELIEF BAKE @ 375 FOR 5 HRS HEAT CHART # 9921. MPI
INSPECTED IAW ASTM E 1444. CADMIUM PLATED IAW AMS-QQ-P-
416B, TYPE 2 YELLOW, CLASS 2. BAKE HEAT CHART # 9967.**

**CERTIFICATE: I certify that the items indicated here on have
been inspected and tested and conform to all specifications
and requirements detailed on the contract or purchase order.**

Approved Inspector:



A large, stylized handwritten signature in black ink.

Date: Thursday, 13/11/2008 10:05:02 AM
User: Julie Dawson

Process Sheet

49

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 43337
Estimate Number : 12485
P.O. Number :
This Issue : 13/11/2008 **S.O. No.** :
Prsht Rev. : NC
First Issue : 12/11/2008 **Type** : CROSSTUBES
Previous Run : 43336
Written By :
Checked & Approved By :
Comment : Est Rev:A New Issue 06-07-05 JLM
Est Rev:B Update qty of MS21042L5 06-09-12 KJ
Est Rev:C Rev B 07-11-15 DD
Est Rev D Combined manufacturing 08.04.02 EC verified by:
DD
Est Rev:E 08-06-24 revD as per dwg DD verified by:EC

Drawing Name : 350/355 AS X-TUBE FWD
Part Number : D350748101
Drawing Number : N/A
Project Number : N/A
Drawing Revision : D
Material :
Due Date : 02/12/2008 **Qty:** 1 **Um:** Each

REFERENCE ONLY

Additional Product

Job Number:



Seq. #: **Machine Or Operation:** **Description :**

1.0 DC DOCUMENT CONTROL



JUD 08.12.08



Comment: Photocopy bluefile & type labels per PPPD350-748-101 CHG001

2.0 D350748141TRN Crosstube Turning Detail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
CROSSTUBE TURNING DETAIL
batch_____

3.0 BENDING BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE
Bend tube as per Dwg D350-748-141 using CNC bender program D350F and Folio FT_____

Job Completion

